

Work Order ID 94678***94678***

Page 1

December-19-12 2:27:24 PM

Item ID: D3969-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Spring (Basket Lid)

Stop

NS2Start Date: 12/19/12 Start Qty: 12.00 ***12***

Cust Item ID:

Required Date: 1/11/13 Req'd Qty: 12.00 ***12***

Customer:

Reference:

Approvals: Process Plan: *R*Date: *12/20/12*

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
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D3969	C	0.00							
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100

100

Purchasing

Memo

Issue P/O: *18714*
Order as per Dwg D3969
Possible supplier: LS Technologies
part#: SSA4/6-122-315-310N
Material release note is required*PL 13-01-7*

110

110

Packaging

Memo

Receive & Inspect for Damage & Mat'l Certs

0.00

PL 13-01-12

Packaging

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS								
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other						
Part No. _____ NCR No. _____													
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector				
Doc/Data													
Equip/Tooling													
Operator													
Material													
Setup													
Other													
Process													
Supplier													
Training													
Unapproved													
FAULT CATEGORY													
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions						<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	

Work Order ID 94678

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94678

Page 2

Item ID: D3969-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Spring (Basket Lid)

Stop

NS2

Start Date: 12/19/12 Start Qty: 12.00

12

Cust Item ID:

Required Date: 1/11/13 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

120

QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

DAS

15

9.69

B-1/10

10

130

Identify as per dwg & Stock Location: ST262

0.00

130

Packaging

Packaging

Memo

0.00

12x

SP
13-01-11

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

0.00

13/1/14 JJ
MF

12-1-R

NCR: Yes / No

WORK ORDER NON-COMPLIANCE / UPDATE

DQA: Date:

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other			
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved											
	FAULT CATEGORY										
	Landing Gear			General							
	Bending	Bend		Grain			Ovalized	Pressure/Forced			
	Centre Not Concentric to O/S	BOM/Route		Hardware			Over/Under tolerance	Temperature/Cure			
	Cracks	Broken/Damaged		Inspection Incomplete			Part Incorrect	Weld			
	Crushed/Crimped.	Burr		Instructions Incomplete/Unclear			Part Lost/Missing	Wrong Stock Pulled			
	Cuffs	Contamination		Maintenance			Part Moved				
	Heat Treat	Countersink		Mislabeled			Positioned Wrong				
	Inspection Strip in Tube	Cut Too Short		Misread			Power Loss/Surge				
Ripples in Bend	Drill Holes		Offset								
Torque Waves in Extrusion	Drawing		Out of Calibration								
Turning Sequence	Finish		Out of Sequence								
Wave/Twist in Tube	Folio		Outside Dimensions								

Picklist Print

December-19-12 2:27:24 PM

Page 1

Work Order ID: 94678

Parent Item: D3969-1

Parent Item Name: Spring (Basket Lid)

Start Date: 12/19/12

Required Date: 1/11/13

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP RevA: New issue DD verified by:EC
10.03.16 verified by:EC

IPP Rev:B as per revC DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
SSA4/6-122-315-310N Gas Spring		Purchased	No			110	Each	0.0000	1	12			

12/19/12 (12)

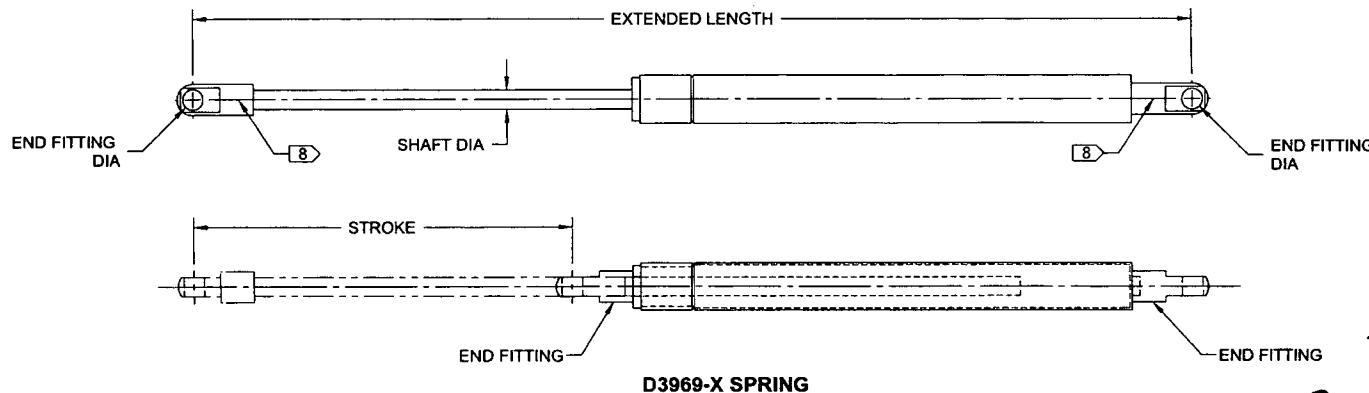
NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

QA Closed: _____ Date: _____

SPECIFICATION CONTROL DRAWING



DART PART NUMBER	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	SHAFT DIA (mm/in)	FORCE (N/lbs)	END FITTING TYPE	END FITTING DIA (in)	CASING MATERIAL	PREFERRED SUPPLIER	SUPPLIER PART NUMBER	WEIGHT APPROX
D3969-1	120/4.70	315/12.40	6/0.24	310/69.7	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/6-122-315-310N	0.27 lbs
D3969-3	120/4.70	315/12.40	8/0.31	360/80.9	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/8-122-310-360N	0.32 lbs
D3969-5	120/4.70	315/12.40	6/0.24	133/29.7	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/6-122-315-133N	0.27 lbs

NOTES:
 1) MATERIAL: SEE CHART
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3969-X" AND B/N USING FINE POINT PERMANENT INK MARKER
 7) WEIGHT: SEE CHART
 8) CRIMP END FITTING AT APPROXIMATE LOCATION SHOWN, PER MANUFACTURERS REQUIREMENTS

C	REDRAWN IN SW. ADDED -3 & -5; ADDED SHAFT DIA COLUMN TO CHART. FORCE FOR -1 CORRECTED (WAS 60.0 lbs).	JPH	10.03.04
B	DRAWING RENAMED WAS: GAS SPRING (BASKET LID).	AJS	08.11.10
A	NOTE 8 ADDED.	AJS	09.07.27
REV.	DESCRIPTION		
DESIGN	AJS	DART AEROSPACE LTD HAWKSLEY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>PP</i>	DRAWING NO.	REV. C
MFG. APPR.	N/A	D3969	SHEET 1 OF 1
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>PP</i>	BASKET LID SPRING	
DATE	10.03.04	NTS	

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO18714

Purchase Order Date 1/4/2013
PO Print Date 1/4/2013

Page Number 1 of 1

Order From :

LS TECHNOLOGIES INC.
314 JESSOP AVE
SASKATOON, SK S7N 1Y6
CA

VC-LST0001

Contact Name
Vendor Phone 306 683 5000
Vendor Fax 306 683 6403
Vendor Account Nbr.

Buyer	Brigitte Golden
Requisition Nbr	
Tax Resale Nbr	10127-2607
Terms	Net 30
Currency	CAD
FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED

Line Nbr	Reference Revision ID	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
	Vendor Part Number						
1	B8-240-575-150N	GAS SPRING	1/9/2013 Yes	10.00 Each	FedEx PI collect	\$41.3640	\$413.64
			Special Inst: As per DWG: D3552 Rev: K <u>B94728</u>				
2	6/15-164/50-115N	Gas Spring	1/9/2013 Yes	10.00 Each	FedEx PI collect	\$63.9000	\$639.00
			Special Inst: As per DWG: D2807 Rev:E <u>B94607</u>				
3	SSA4/6-122-315-310N	Gas Spring	1/9/2013 Yes	12.00 Each	FedEx PI collect	\$65.0000	\$780.00
			Special Inst: As per DWG: D3969 Rev: C <u>B94678</u>				

CERTIFICATE OF CONFORMITY
REQD UPON DELIVERY

Change Nbr: 1

Change Date: 1/4/2013

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required - YES NO

LS TECHNOLOGIES INC

314 Jessop Ave
Saskatoon, SK S7N 1Y6

Ph # (306) 683-5000

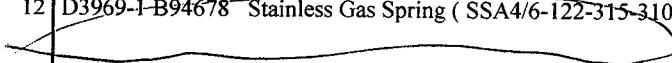
Packing Slip

P.O. No.	Date	Invoice #
PO18714	1/08/2013	9386

Name / Address
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship To
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship	Via	FOB
1/08/2013	Fed-Ex	

	Qty	Description
	10 D3552-11 B94728 Gas Spring 10 D2807-041 B94728 Stainless Gas Spring 12 D3969-1-B94678 Stainless Gas Spring (SSA4/6-122-315-310N)	 Shipping Via FED EX Tracking # 794472171502



L S Technologies Inc
314 Jessop Ave
Saskatoon, SK, S7N 1Y6
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

Jan 08, 2013

10 Units: D3552-11 Carbon Steel Gas Spring

10 Units: D2807-041 Stainless Gas Spring

12 Units: D3969-1 Stainless Gas Spring

Country of Manufacture: Canada

Date of Manufacture : Jan 2013

This product is ROHS compliant.

Purchase Order # 18714

Invoice # 9386

L S Technologies Inc Canada

Nolan Fehr
Manager